

Work Order ID 142646

Friday, March 11, 2016 9:58:07 AM

646.9701
B 142646
REV. D***142646***

Page 1

Item ID: 646.9701

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cutter Sub Assembly

Start Date: 3/21/2016 Start Qty: 3.00

3

Cust Item ID:

Required Date: 3/31/2016 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals: Process Plan: MUS Date: **MAR 11 2016**

Tooling:

Date:

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
646.9700	REV D

110 Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

3x 16/03/15

120

0.00

120

Small Fab

Memo

0.01

Small Fab

Assemble as per dwg and apply loctite 598 on all faying surfaces per note.

A/R RTV LOCTITE 598: M134260
exp. date: 07/17

3x 16/03/15

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

(3) 38 9-89

MAR 23 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 142646

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142646

Page 2

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Item Name: Cutter Sub Assembly

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location: <u>CC1012</u>	0.00							
140									
Packaging	Memo	0.00				DAS 6			
Packaging	***IDENTIFY AS PER IAW MPP-120***					9-89			MAR 24 2016
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							MCS MAR 29 2016
Quality Control									

20160328

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
		OTHER : ☐							

Picklist Print

Friday, March 11, 2016 9:58:07 AM

Page 1

Work Order ID: 142646

142646

Parent Item: 646.9701

646 9701

Parent Item Name: Cutter Sub Assembly

Start Date: 3/21/2016

Required Date: 3/31/2016

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP REV:A 12.08.13 NEW ISSUE DD VERF:JFS
:B AS PER REV D 16-03-07 JLM VERIFIED BY:JFS

IPP REV

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
646.9710 *646 9710* Body		Manufactured	No				Each	6.0000		3		16/03/15	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				CCK013				6					
				128805				3					
				130854				3		3			
646.9711 *646 9711* Blade		Manufactured	No			110	Each	38.0000	2	6		16/03/15	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				CCK108A				38					
				136098				20					
				138180				18		6			
MS27039-08-19 *MS27039-08-19* Screw		Purchased	No			110	Each	1,040.000	6	18		16/03/15	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				CCK06				200					
				m134142				200					
				GA				677					
				m132930				84					
				m133077				22					
				m134063				571		18			
				over006				100					
				m134294				100					
				ST277				63					
				m133769				63					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

Friday, March 11, 2016 9:58:07 AM

Page 2

Work Order ID: 142646

142646

Parent Item: 646.9701

646.9701

Parent Item Name: Cutter Sub Assembly

Start Date: 3/21/2016

Required Date: 3/31/2016

Start Qty: 3.00

Required Qty: 3.00

NAS1149FN832P

Purchased

No

110

Each

3,671.000

12

36

NAS1149FN832P

Washer

**

16/03/15
DAS
36
9-89

Location

Loc Qty

Loc Code

GA

1361

M133316

16

M133769

1345

ST260a

1200

M134257

1200

ST262

1110

M133709

1110

36
18

MS21042L08

Purchased

No

110

Each

1,645.000

6

18

MS21042L08

Nut

**

16/03/15
DAS
36
9-89

Location

Loc Qty

Loc Code

CA

101

m129682

101

GA

161

m133134

3

m134063

158

OVER007

500

m134063

500

ST303

483

m133922

483

ST308

400

m134376

400

18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

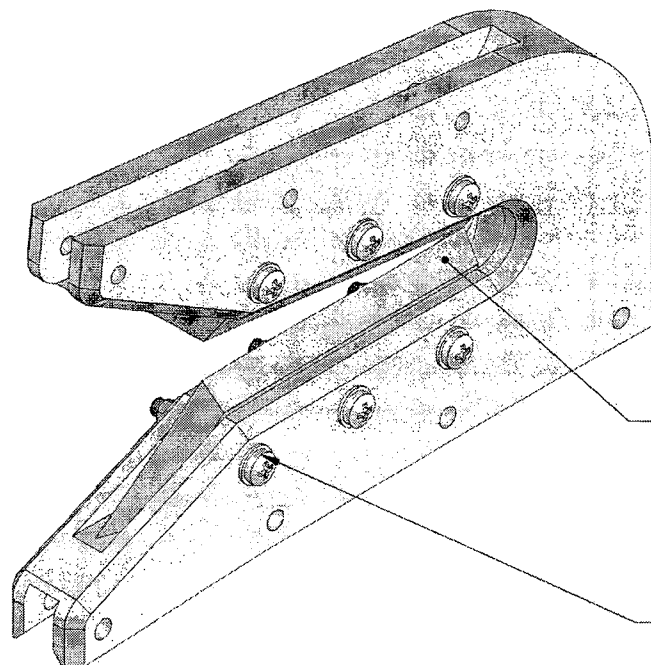
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

142646
16-03-11



646.9701 SHOWN
646.9702 & 646.9703 TYP

- ① OR ⑦ OR ⑧
② 2PL
③ 6PL
④ 12PL
⑥ 6PL

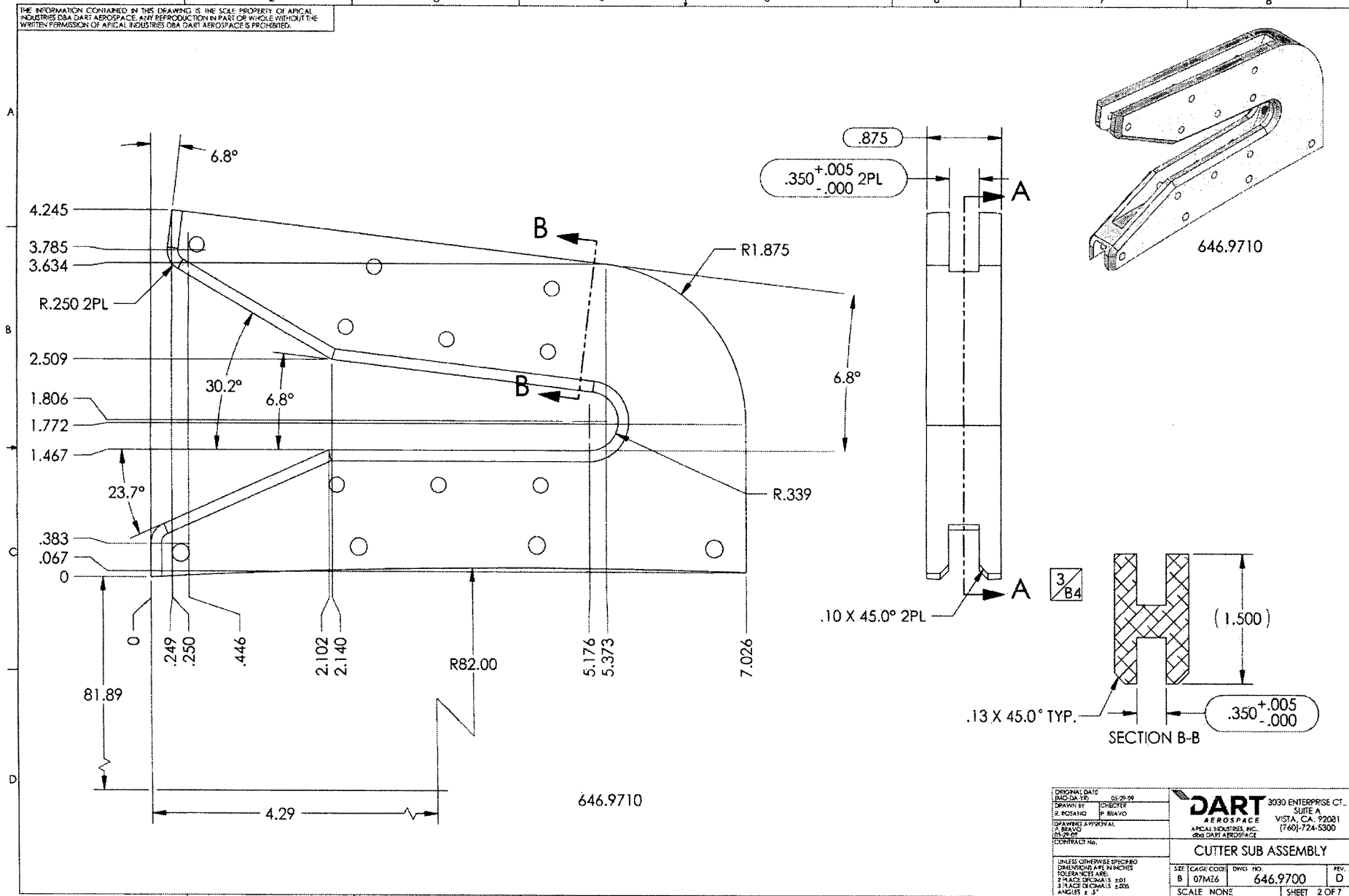
NOTES:

- ① MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12
- ② FINISH IAW MPP-172 SECTION 3.3 & 4.3.
- ③ MATERIAL: AISI A2 TOOL STEEL
CONDITION: ANNEALED
POST PROCESS: HEAT TREAT TO 58-62 Rc ROCKWELL HARDNESS
- ④ FINISH: PRIME IAW MPP-172 SECTION 3.3; 1-2 MIL MAX
5. DEBURR AND BREAK ALL SHARP EDGES EXCEPT WHERE OTHERWISE NOTED
6. IDENTIFY IAW MPP-120
- ⑦ APPLY F/N 5 AS REQUIRED TO ALL FAYING SURFACES OF F/N 2 UPON ASSEMBLY
- ⑧ CUTTING EDGE INTENDED TO BE SHARP, DO NOT BREAK SHARP EDGE
- ⑨ ALL DIMENSIONS NOT SPECIFIED ARE CONTROLLED BY 646.9710.

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	LAST PROTOTYPE REVISION: PR2		N/C
ARC	INITIAL RELEASE	03/29/09	P. BRAVO
A	INCORPORATED ECH 02744, ECH 031, CIP 12	06/06/10	P. BRAVO
B	INCORPORATED ECH 02867	07/03/10	P. BRAVO
C	INCORPORATED ECH 04039	08/09/10	P. BRAVO
D	INCORPORATED ECH 05029	02/26/10	P. BRAVO

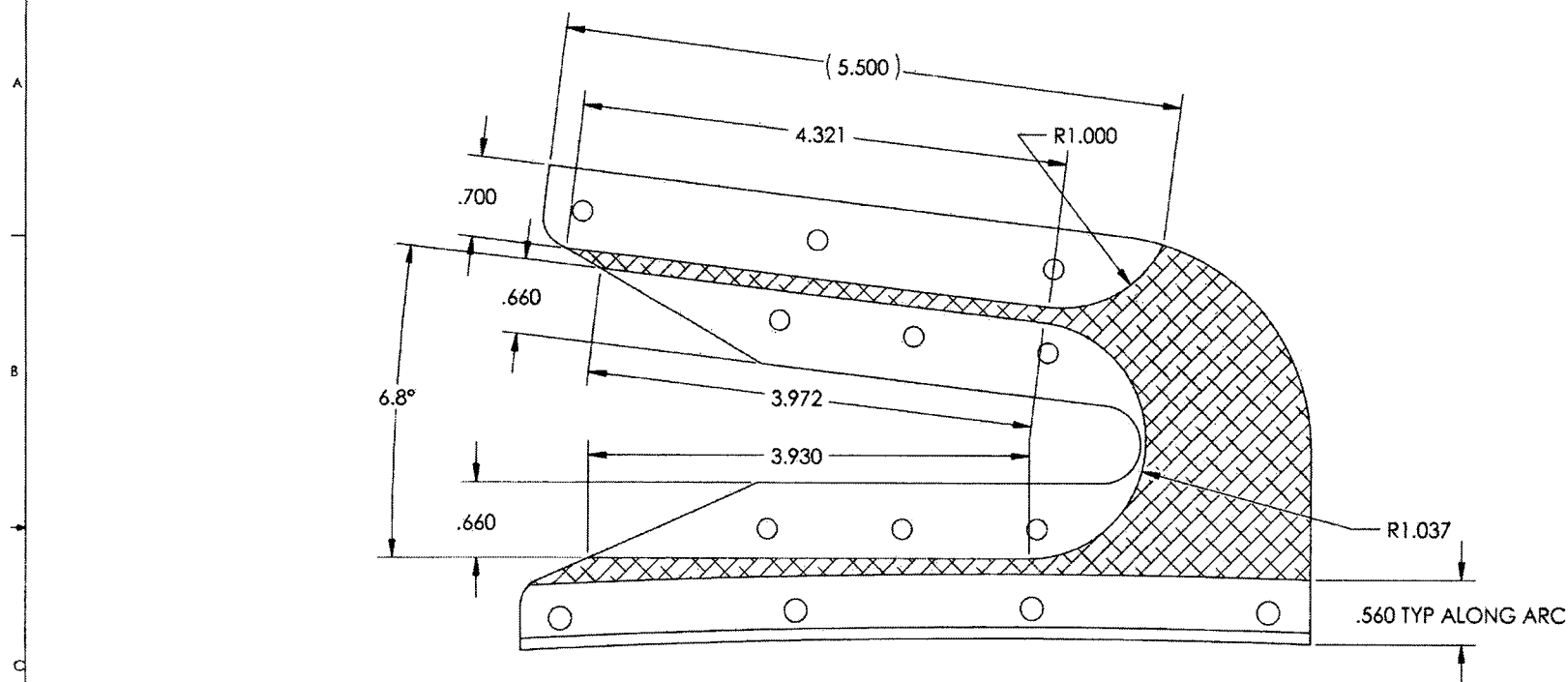
1			8	646.9713	BODY	△	△△
	1		7	646.9712	BODY	△	△△
6	6	6	6	601.1541	LOCKNUT	MS21042L05	
A/R	A/R	A/R	5	601.2045	RTV, LOCITE 598		
12	12	12	4	601.2764	WASHER	A4-81145F4832P	
6	6	6	3	601.2765	SCREW	MS27039-06-19	
2	2	2	2	646.9711	BLADE	△	△
			1	646.9610	BODY	△	△
X				646.9703	CUTTER SUB ASSY		
	X			646.9702	CUTTER SUB ASSY		
		X		646.9701	CUTTER SUB ASSY		
5703	9102	5701	FIND #	PART #	DESCRIPTION	MATL	SPEC.
PARTS LIST							
QTY				NEXT ASSY (S)			
646.9600				ORIGINAL DATE JMD-DAT: 06-22-09 DRAWN BY: P. ROSANO CHECKED BY: P. BRAVO DRAWING APPROVAL P. BRAVO DATE: 06-22-09 CONTRACT NO.			
				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS: ±.001 ANGLES: ±.5°			
				DART AEROSPACE 3030 ENTERPRISE CT., SUITE A VISTA, CA 92081 (760)-724-5300			
				CUTTER SUB ASSEMBLY			
				REV D			
				SCALE: NONE			
				SHEET 1 OF 7			

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ORIGINAL DATE 05/26/99		3030 ENTERPRISE CT., SUITE A VISTA, CA 92081 (760) 724-5300	
DRAWN BY P. BIAVO	CHECKED P. BIAVO	DART AEROSPACE AIRCAL INDUSTRIES INC. DBA DART AEROSPACE	
DRAWING APPROVAL P. BIAVO 05/26/99		CUTTER SUB ASSEMBLY	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONS DECIMALS ±.01 SURFACE DECIMALS ±.001 ANGLES ± .5°		SIZE B	REV. D
CAGE CODE 07M26		DWG. NO. 646.9700	
SCALE NONE		SHEET 2 OF 7	

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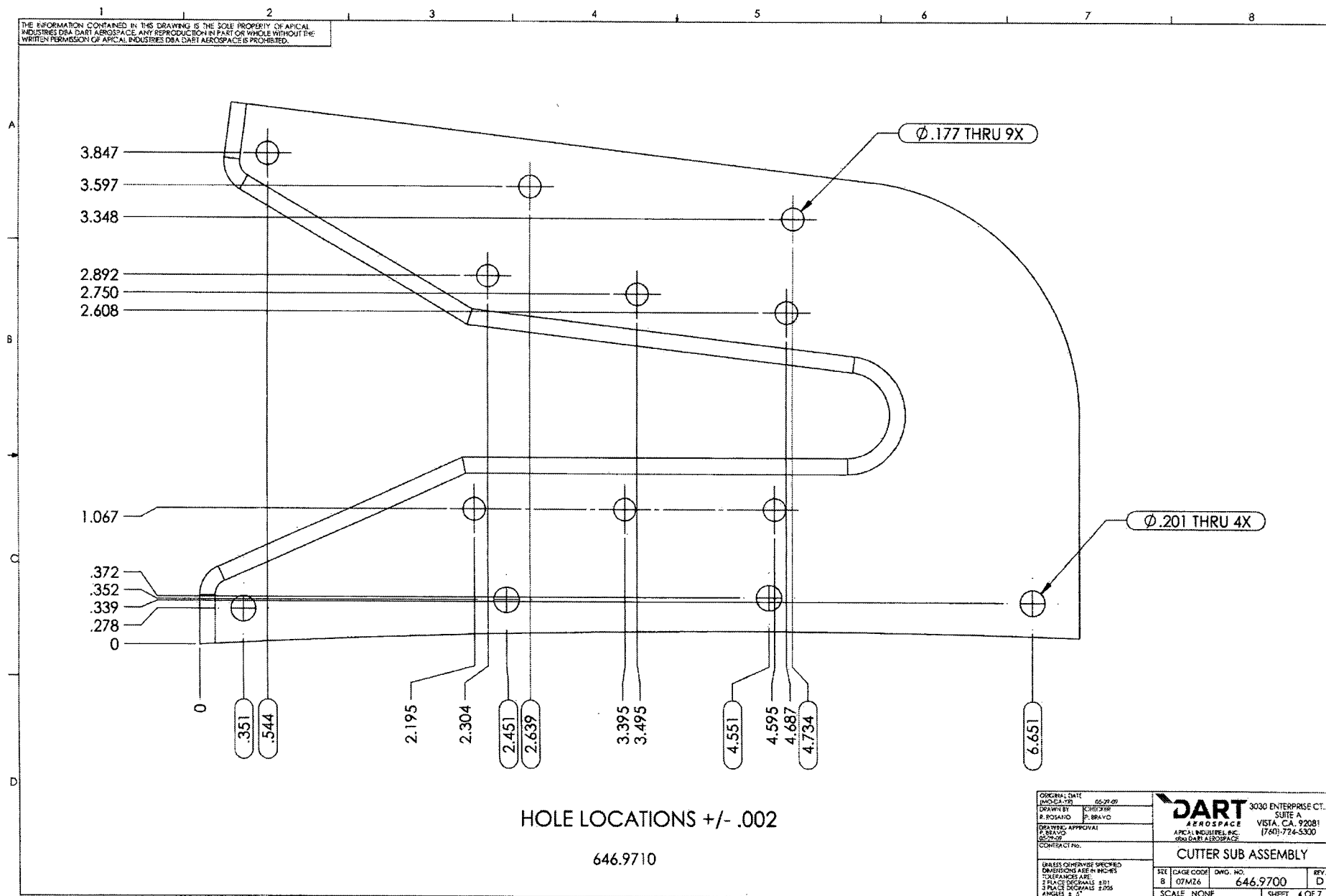


SECTION A-A $\frac{2}{C6}$

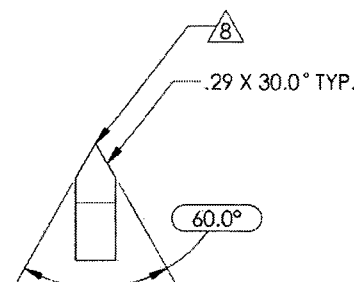
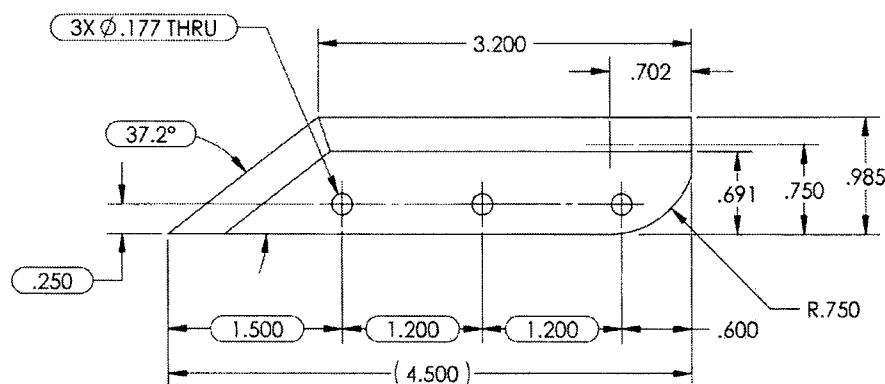
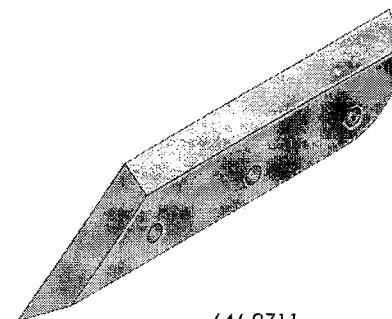
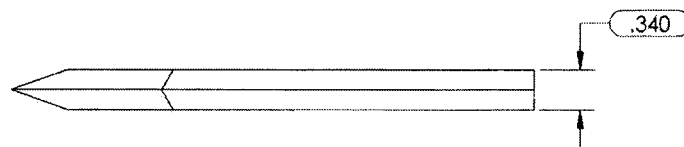
646.9710

ORIGINAL DATE 05-24-99		3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760)-724-5300	
DESIGNED BY V. ROSANO	CHECKED BY T. BRAVO	DART AEROSPACE AFICAL INDUSTRIES INC. DBA DART AEROSPACE	
DRAWING APPROVAL T. BRAVO 05-28-99	CONTRACT NO.		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS .001 3 PLACE DECIMALS .0005 ANGLES ± .5°		REV. NO. B 07/11/16	REV. D
SCALE NONE		646.9700	
		SHEET 3 OF 7	

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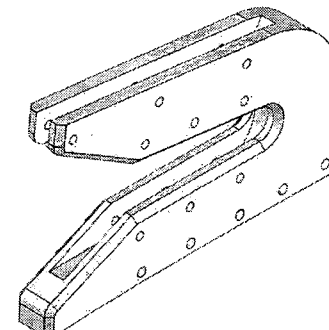
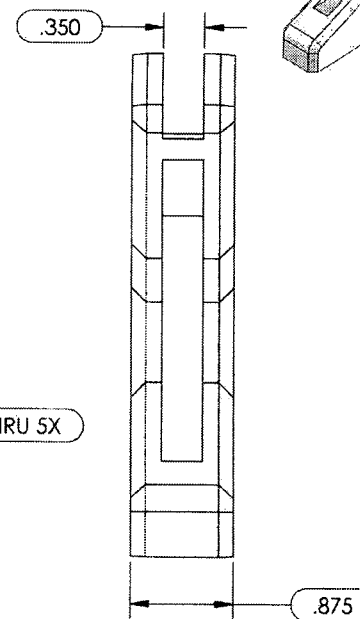
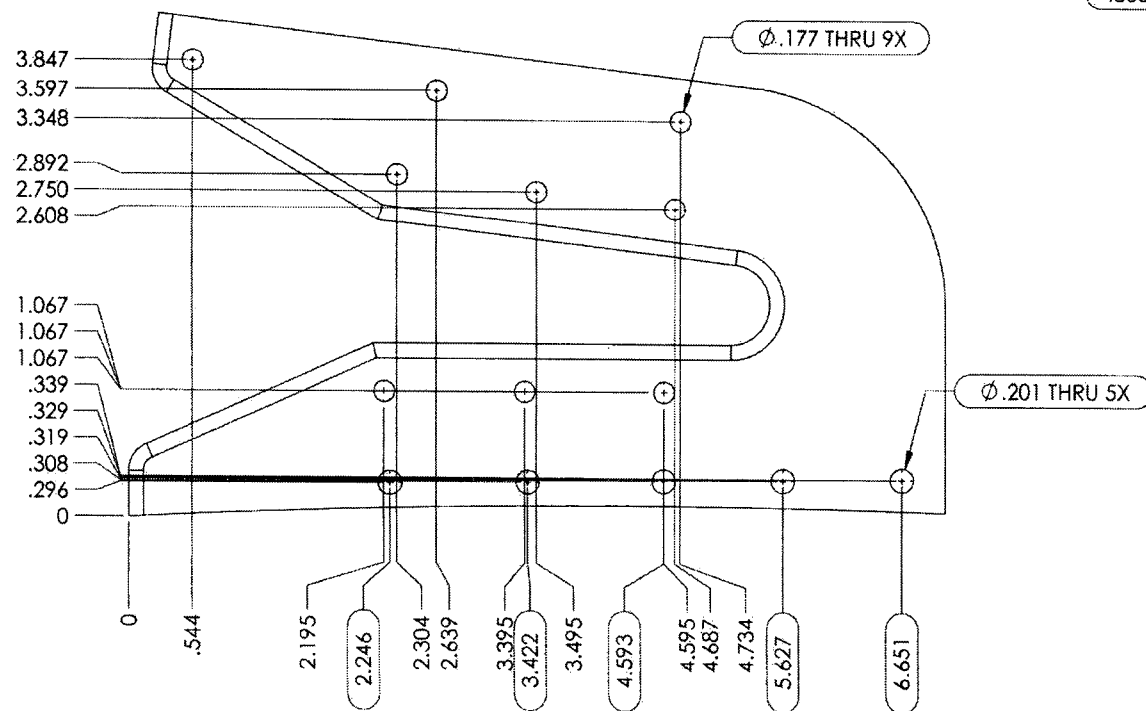
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646.9711

ORIGINAL DATE 05-29-09		3030 ENTERPRISE CT. SUITE A VISTA, CA 92081 (760) 724-5300	
DRAWN BY S. ROSARIO		CHECKED P. BRAYO	
DRAWING APPROVAL 05-29-09		APICAL INDUSTRIES INC. DBA DART AEROSPACE	
CUTTER SUB ASSEMBLY		CUTTER SUB ASSEMBLY	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°	SHEET B	DWG. NO. 07M16 646.9700	REV. D
SCALE NONE		SHEET 5 OF 7	

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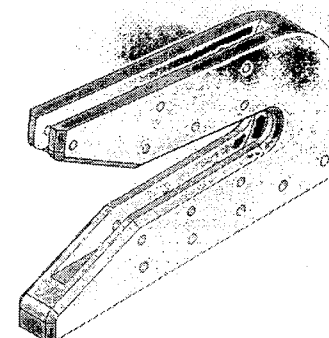
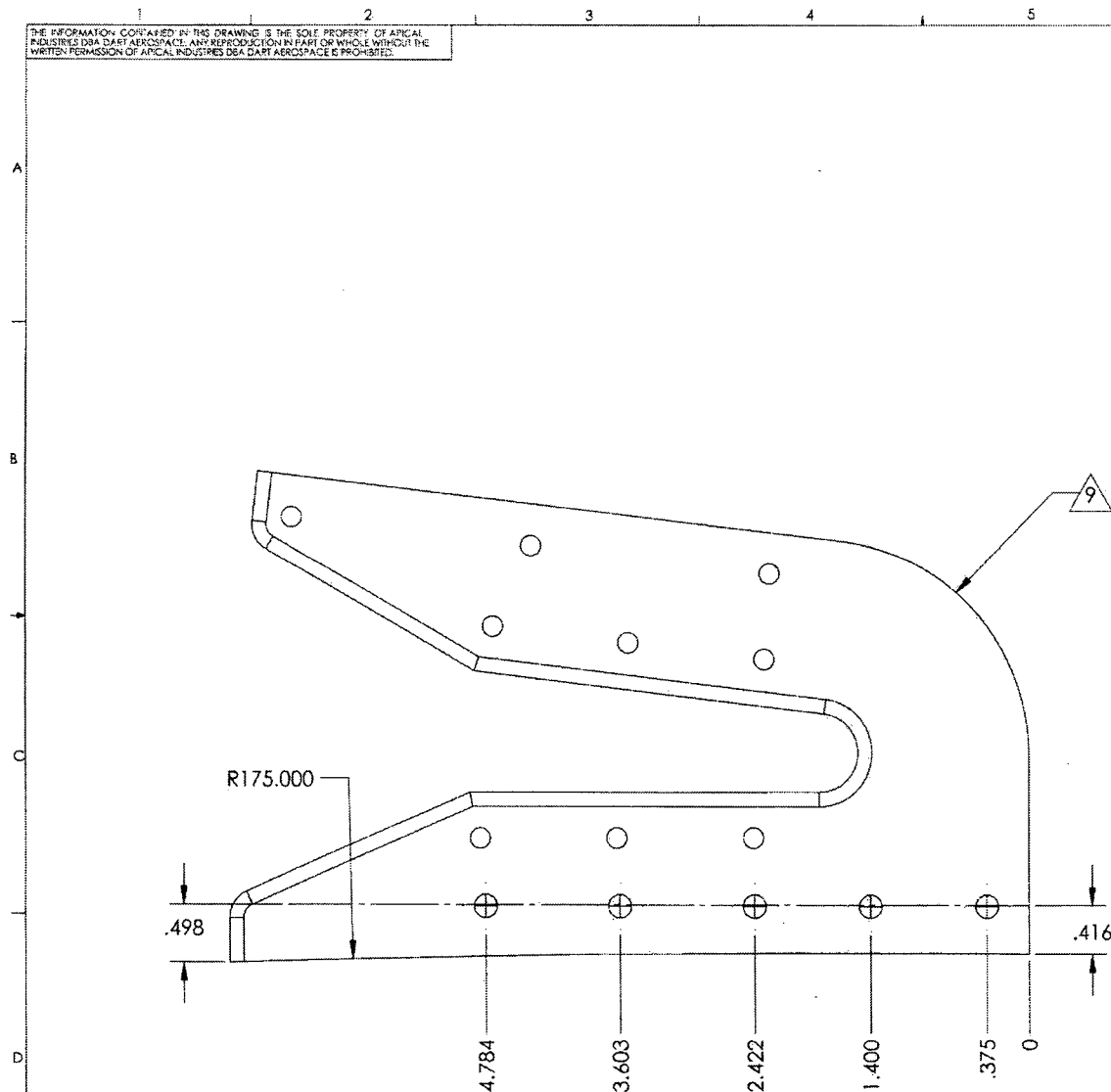


646.9712 $\triangle 9$

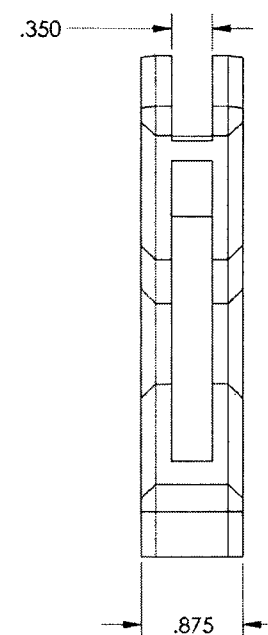
646.9712

ORIGINAL DATE END DATE		05/20/00	
DRAWN BY K. ROSARIO		P. BOALVO	
DRAWING APPROVAL P. BOALVO		DART AEROSPACE	
CONTRACT NO.		3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760) 724-6300	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .01$ 3 PLACE DECIMALS $\pm .005$ ANGLES $\pm .1^\circ$		SHEET B	REV. D
CAGE CODE 07M26		DWG. NO. 646.9700	SHEET 6 OF 7
SCALE NONE		CUTTER SUB ASSEMBLY	

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646.9713



ORIGINAL DATE: 05/21/09		DART AEROSPACE		3030 ENTERPRISE CT., SUITE A	
DRAWN BY: E. ROSA NO. P. BRAVO		APICAL INDUSTRIES INC. DBA DART AEROSPACE		VISTA, CA 92081 (760) 724-5300	
DRAWING APPROVAL: P. BRAVO 05/29/09		CUTTER SUB ASSEMBLY			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		SHEET: 07M26	DWG. NO.: 646.9700	REV.: D	SCALE: NONE
		SHEET 7 OF 7			